

Work Order ID 76655

76655

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November-18-11 10:40:51 AM

Item ID: D2324 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut
 Start Date: 18/11/2011 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 02/12/2011 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 11/11/18 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2324	Rev C								

100 Small Fab 0.00
100
 Small Fab Memo 0.00 SB 11/11/22 24
 Small Fab Assemble as per Dwg D2324.

110 QC5- Inspect part completeness to step on W/O 0.00
110
 QC Memo 0.00 5 11/11/23 count
 Quality Control

120 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00
120
 Powdercoat Memo 0.00 2:30
 Powder Coating START TIME: 3:00 FINISH TIME: 3:30 24X Ø 11/11/23

W 118439

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

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Picklist Print

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Work Order ID: 76655

76655

Parent Item: D2324

D2324

Parent Item Name: Strut

Start Date: 18/11/2011

Required Date: 02/12/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: E03.02.28Reformat; Incorporated D2324-3 & D2324-5KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN3-12A		Purchased	No			100	Each	137.0000	2	24			
AN3-12A									**			SB 11/11/22	
Bolt													

Location	Loc Qty	Loc Code
ST351	137	
114536	1	
116786	36	
119641	100	

AN960JD10	NAS1149D0363J	Purchased	No			100	Each	0.0000	4	48			
AN960.ID10									**			SB 11/11/22	
Washer													

D2324-3		Manufactured	No			100	Each	0.0000	1	12			
D2324-3									**			SB 11/11/22	
Bar													

D2324-5		Manufactured	No			100	Each	1.0000	2	24			
D2324-5									**			SB 11/11/22	
Strap													

Location	Loc Qty	Loc Code
GA	1	
71596	1	
76490		
B76505		

5
42

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Picklist Print

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Work Order ID: 76655

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Parent Item: D2324

D2324

Parent Item Name: Strut

Start Date: 18/11/2011

Required Date: 02/12/2011

Start Qty: 12.00

Required Qty: 12.00

MS21042L3

Purchased

No

100

Each

8,736.000

2

24

MS21042L3

SB

11/11/22

Nut

Location

Loc Qty

Loc Code

ST300

255

117441

16

117885

35

118451

5

118927

199

ST516

6000

119017

6000

ST518

2481

119075

2481

48

Dart Aerospace Ltd

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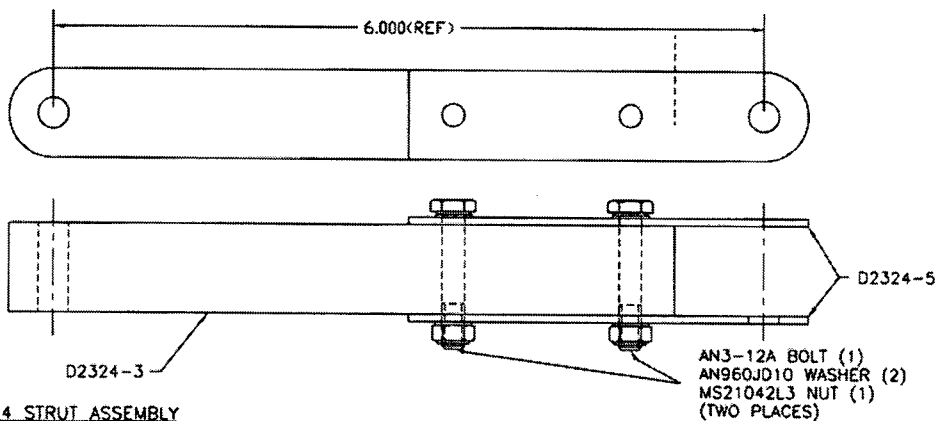
NOTE: Date & initial all entries

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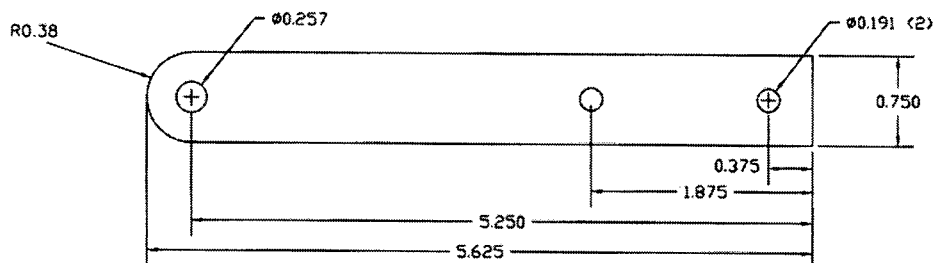
DESIGN B WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2324	REV. C SHEET 1 OF 1
DATE 04.12.14	TITLE STRUT		SCALE
A	94.11.08	NEW ISSUE	
B	96.05.07	UPDATE MATERIALS	
C	04.12.14	UPDATE NOTES	

RELEASED
04.12.16 #



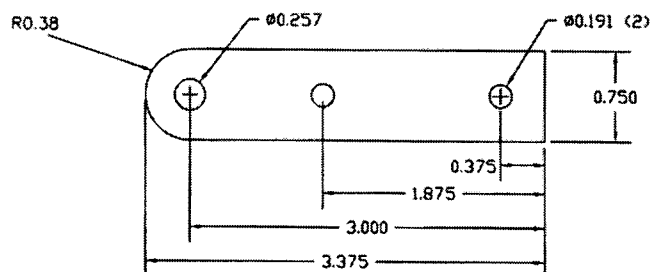
D2324 STRUT ASSEMBLY

- 1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324-3

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2324-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76055 M.C.J.
11/11/18

Dart Aerospace Ltd

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